

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026151**Date Inspected:** 24-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** John Pagliero**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. 8E PP67.2 (Exterior)
2. 8E PP69.2 (Exterior)
3. 11W 12W North side (Interior)
4. 11W 12W South side (Interior)

1. 8E PP67.2 (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing Shielded Metal Arc Welding (SMAW) in the 1G flat, 3G vertical and 4G overhead positions on 2.5 inch schedule 80 pipe weld #13/2.5/67/NE and 4 inch schedule 80 pipe weld #13/4/67/NE located at 8E PP67.2. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed implementing 6010 electrodes in the root pass with the balance using 7018 electrodes all of which in an uphill progression.

The QA inspector made subsequent observations through completion to monitor quality and noted that the work appears to be in general conformance with the contract documents.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

2. 8E PP69.2 (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing SMAW in the 1G flat, 3G vertical and 4G overhead positions on 2.5 inch schedule 80 pipe weld #14/2.5/69/NE and 4 inch schedule 80 pipe weld #14/4/69/NE located at 8E PP69.2. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed implementing 6010 electrodes in the root pass with the balance using 7018 electrodes all of which in an uphill progression.

The QA inspector made subsequent observations through completion to monitor quality and noted that the work appears to be in general conformance with the contract documents.

3. 11W 12W North side (Interior)

The QA Inspector performed a Magnetic Particle Test (MT) on Longitudinal Stiffeners (LS) 1, 2 and 3 at 11W 12W on the north side interior of the OBG. The QA Inspector tested 100% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. The QA Inspector noted that the work appeared to be free of defects and was found to be acceptable and in general conformance with the contract documents. Upon completion of the MT, the QA Inspector performed Ultrasonic Testing on 100% of the weld utilizing a G.E. /Krautkramer USN 60. The QA Inspector also utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4 during the examination. Upon completion of the testing, it was noted by the QA Inspector that no indications were present and the work was found to be acceptable.

4. 11W 12W South side (Interior)

The QA Inspector performed a Magnetic Particle Test (MT) on Longitudinal Stiffeners (LS) 4, 5 and 6 at 11W 12W on the south side interior of the OBG. The QA Inspector tested 100% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. The QA Inspector noted that the work appeared to be free of defects and was found to be acceptable and in general conformance with the contract documents. Upon completion of the MT, the QA Inspector performed Ultrasonic Testing on 100% of the weld utilizing a G.E. /Krautkramer USN 60. The QA Inspector also utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4 during the examination. Upon completion of the testing, it was noted by the QA Inspector that no indications were present and the work was found to be acceptable.

Summary of Conversations:

At the beginning the shift the QA inspector met with QC inspector William Sherwood and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
